

Work Order ID 85096

85096

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June-01-12 3:43:11 PM

Item ID: D350-589-011

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Side Door Latch Modification

Stop *NS2*

Start Date: 01/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/09

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
INN-D350-589	E								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file and type label as per PPP D350-589-011 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

DAS 15 9:53 12/06/09

4x MLJ 12-8-8

4x SP 12-8-8

DAS 15 9:53 12/06/09

(x4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-589-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door Latch Modification

Start Date: 01/06/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
130		0.00							
130	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

Rev A 122

12/8/13 AJ

R12-08-10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 85096

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	12			
-----------	---------------	-----------	----	--	--	-----	------	--------	---	----	--	--	--

AN960.ID10

Washer		Manufactured	No			105	Each	56.0000	3	12			
--------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2237

Striker Plate

Location

Loc Qty

Loc Code

ST006

56

66139

1

82062

15

83376

40

D2583		Manufactured	No			105	Each	27.0000	3	12			
-------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2583

Latch Bracket

Location

Loc Qty

Loc Code

ST011

27

82070

3

83445

24

D2585		Manufactured	No			105	Each	24.0000	3	12			
-------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2585

Mounting Channel

Location

Loc Qty

Loc Code

ST011

24

73297

2

83369

22

** 12
m/22378 SP

** 12
B64426 2x. SP
B

** 12
3x
7x

** 12
SP

** 12
B82029 SP
SP 12-8-8

** 12
4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

*D2586

Manufactured No

105

Each

19.0000

D2586

Door Latch

Location

Loc Qty

Loc Code

ST203A

19

78833

19

105

Each

27.0000

D2587

Manufactured No

D2587

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST011

27

74522

1

78893

26

105

Each

0.0000

D2589

Manufactured No

D2589

Keys, Key Chain, 350 Hinge

MS20470AD4-5

Purchased No

MS20470AD4-5

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1494

118405

483

120142

1011

105

Each

1,494.000

** 3 12

B57917 IX. SP.
B83893 11 K

** 0 4

SP

** 0 4

B 58194 SP

** 6 24

SP 12-8-8

24K

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Parent Item Name: Side Door Latch Modification

85096

D350-589-011

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

105

Each

2,195.000

12

MS21042L3

Screw Nut

**

m122141 SP

Location

Loc Qty

Loc Code

ST300

2195

117885

32

119017

952

119075

138

121349

221

121444

852

MS27039-1-15

Purchased

No

105

Each

47.0000

12

MS27039-1-15

Screw

**

m1224595x

SP 12-8-8.

Location

Loc Qty

Loc Code

ST291

47

118574

2

119736

1

121243

44

7x.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC-Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
1	1	1	1	D2464-1700	Seal
3	1	1	1	D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1	1	1	1	D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00